

Date: Thursday, 18/12/2008 12:51:14 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 44162	
Estimate Number : 10546	
P.O. Number :	Part Number : D30631
This Issue : 18/12/2008 S.O. No. :	Drawing Number : D3063 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/12/2008 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 41031	Material :
Written By :	Due Date : 23/12/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JUD 08.12.19</u>	
Comment : Est:C 02.10.04 Re-format; Blank size change KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0625X02500	6061-T6 Bar .625 x 2.50
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Comment: Qty.: 0.3588 f(s)/Unit Total : 14.3514 f(s)
 6061-T6 Bar .625" x 2.5"

Material 6061-T6 (QQ-A-200/8 or QQ-A-225/8 or QQ-A-250/11) (M6061T6B0.625x2.500 or
 M6061T6S.625) Batch: M1089601 DJP 08/12/31 (40)

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks 4.000" x 2.500" x 0.625" thick

DJP 08/12/30 (40)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio FA175 and Dwg D3063
 2-Deburr & Tumble

DJP 08/12/30 (39)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 08/12/31 (39)

5.0	QC8	SECOND CHECK
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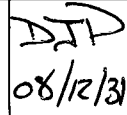

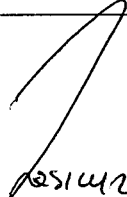
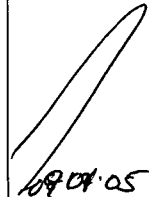


Comment: SECOND CHECK

Y.A 09/01/05 (39)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3863-1 PAR #: NA Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 09/01/06
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44162</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/31	3.0	I part is scrap, 0.188" dim. is 0.010" under tolerance. Part as lifted in jaws L.C. Process		Scrap & destroy, No replace	 08/12/31	 09.01.05	 08/12/31	 09.01.05

NOTE: Date & initial all entries

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Drawing Name: SUPPORT

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Part Number: D30631

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PAT E.

AS 09/01/06 (44)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/06

Job Completion



mf 09-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

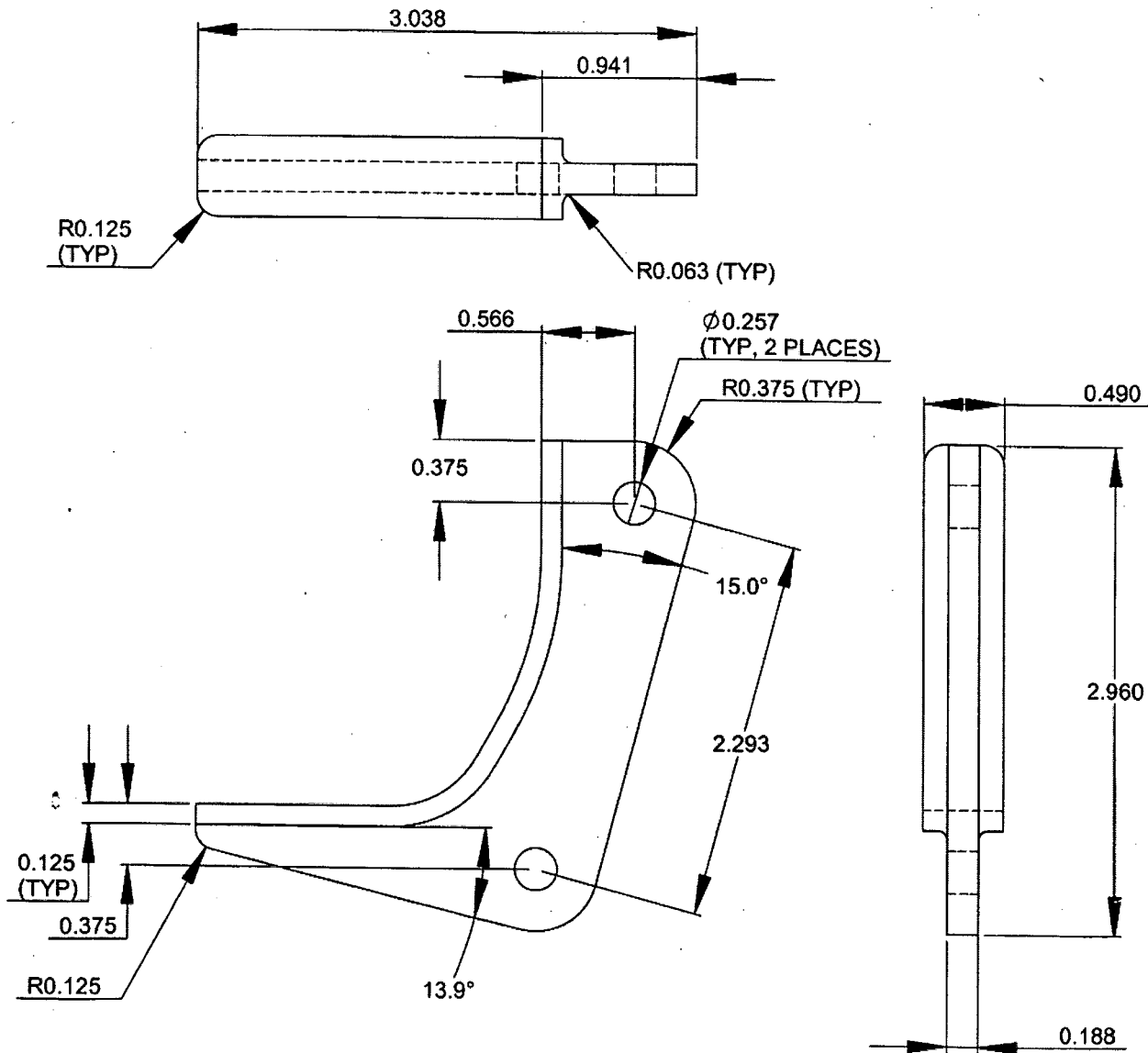
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3063	REV. A
DATE 02.09.10		TITLE SUPPORT	SHEET 1 OF 1
A	02.09.10	NEW ISSUE	SCALE 1:1

RELEASED
02.09.20 *#*



D3063-1 SUPPORT

- 1) MACHINE PER DWG FILE "D3063-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)
(REF DART SPEC M6061T6B OR M6061T6S)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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